












Date: Tuesday, 15/07/2008 9:14:17 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001. Dart Helicopters Services	Drawing Name	: BACK LEG FITTING
Job Number	: 40481	Part Number	: D37641
Estimate Number	: 13293	Drawing Number	: D3764 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 15/07/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 30/07/2008
Previous Run	: 39109	Qty:	8 Um: Each
Written By	:		
Checked & Approved By	: <u>JUD 08.15.08.</u>		
Comment	: Est Rev:A New Issue 08-05-01 JLM	Verified By:	EC
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X02000	6061-T6 Bar 1.5 x 2.0	
			
Comment: Qty.: 0.2625 f(s)/Unit Total: 1.0500 f(s) 6061-T6 Bar 1.5 x 2.0 Batch: <u>M18147</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blank 2.95" long			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA741 Rev: <u>AA</u> & Dwg D3764 Rev: <u>B</u> 2-Deburr per dwg D3764			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3764-1 PAR #: 08-024 Fault Category: Prod/Eng - Cardinal NCR: Yes No DQA: D Date: 08/07/29  
 QA: N/C Closed: D Date: 08/07/29

NCR: <u>40481</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/07/18</u>	<u>3</u>	<u>1 part scrapped ran at</u> <u>PAR 08-024</u> <u>P.C. off sets were set at</u> <u>Zero. and one part</u> <u>Scrap</u>	<u>[Signature]</u>	<u>Scrap + replace</u> <u>Bk 18/47 QTY @</u>	<u>JL</u> <u>08/07/18</u>	<u>[Signature]</u> <u>08/07/21</u>	<u>[Signature]</u> <u>08/07/21</u>	<u>[Signature]</u> <u>08/07/21</u>
				<u>Adjust Program.</u>	<u>[Signature]</u> <u>08-07-21</u>			

NOTE: Date & initial all entries

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Drawing Name: BACK LEG FITTING

Job Number: 40481

Part Number: D37641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(8X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

20/11/08 08/07/21

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F-2 08/07/21

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 119

08/07/21 (8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

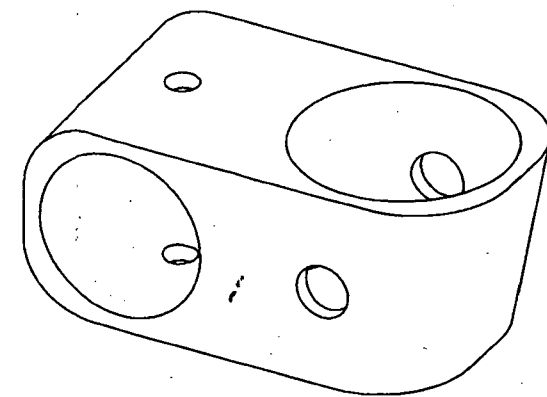
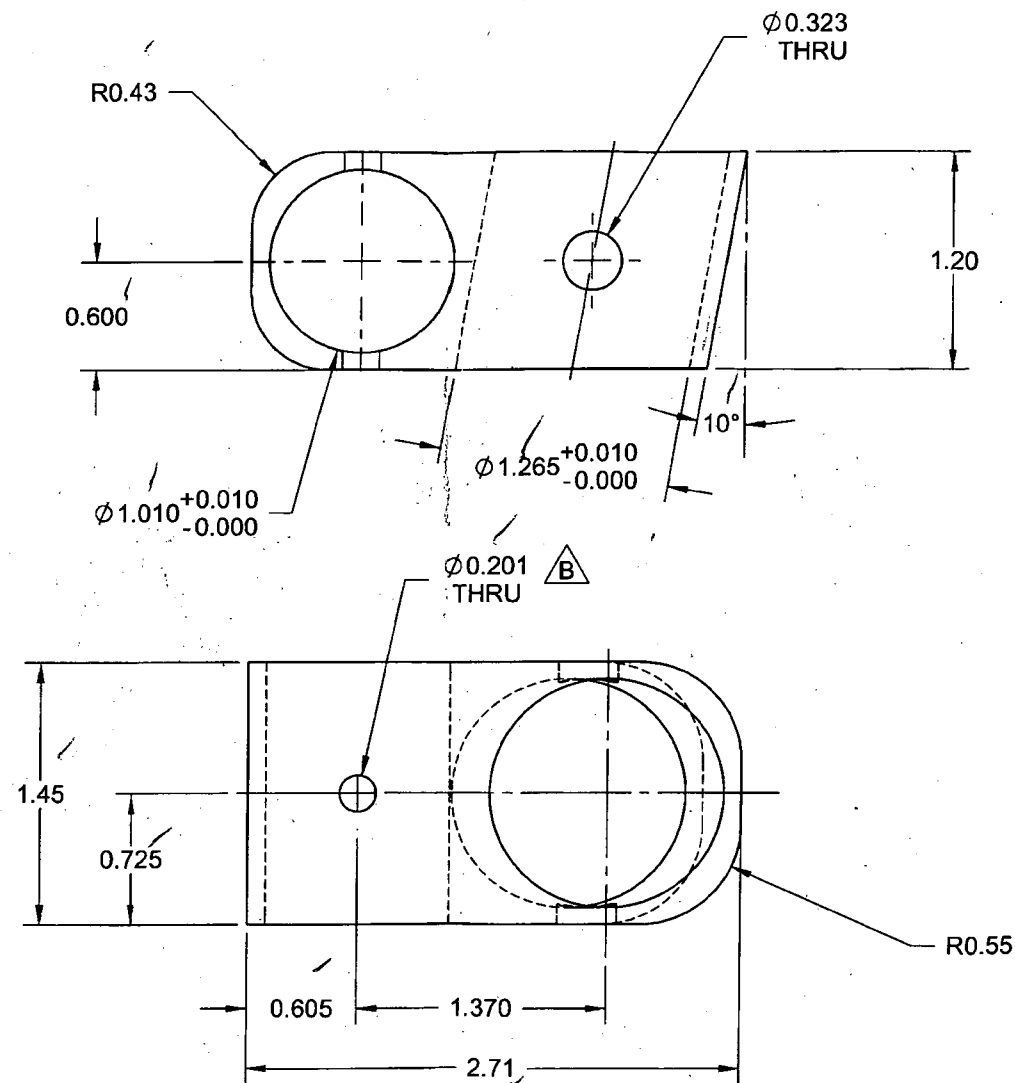
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3764-1 BACK LEG FITTING**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.		D3764	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BACK LEG FITTING	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. 46481

